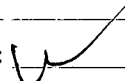




Work Order ID 72512

Wednesday, July 27, 2011 1:57:55 PM

Page 1

Item ID: DSI 9464-011 Accept  Setup Start 
Revision ID: Stop 
Item Name: Skidtube Tuning
Start Date: 7/27/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 7/27/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A								
DSI 9464	B								

100

0.00



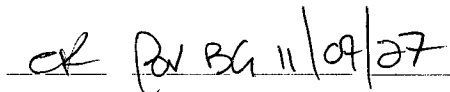

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

0.00

 11/09/07

110

Pick Kit

0.00

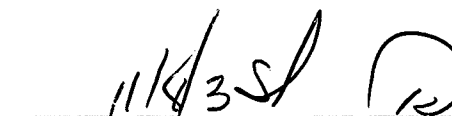


Packaging

Memo

Packaging

0.00

 11/03/07

Work Order ID 72512

Wednesday, July 27, 2011 1:57:55 PM



Page 2

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Tuning

Start Date: 7/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/09

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9464-011

Location: 201PPP rev: A

11/8/09

12

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CR 11/08/09

11-08-09
①

Picklist Print

Page 1

Wednesday, July 27, 2011 1:57:52 PM

Work Order ID: 72512

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning



Start Date: 7/27/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-553 DD 10.04.19 verified byEC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3955-041 Doubler Assembly		Manufactured	No			110	Each	5.0000	2	2			
<div> <div>Location</div> <div>ST098</div> <div>69048</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3955-3 Cover Plate		Manufactured	No			110	Each	2.0000	2	2			
<div> <div>Location</div> <div>ST097</div> <div>69049</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3955-5 Plate		Manufactured	No			110	Each	7.0000	2	2			
<div> <div>Location</div> <div>ST097</div> <div>69050</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>7</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3955-7 Plate		Manufactured	No			110	Each	7.0000	6	6			
<div> <div>Location</div> <div>ST098</div> <div>69051</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>7</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

4

2

2

2

11/10/3 ST

D

6

Picklist Print

Wednesday, July 27, 2011 1:57:52 PM

Page 2

Work Order ID: 72512

Parent Item: DSI 9464-011


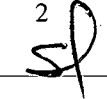

Parent Item Name: Skidtube Tuning

Start Date: 7/27/2011

Required Date: 7/27/2011


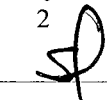

Start Qty: 1.00

Required Qty: 1.00

D3955-21 Manufactured No 110 Each 4.0000  2 

 Gasket


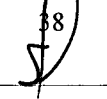

Location Loc Qty Loc Code

ST098 4
 67410 4

D3955-23 Manufactured No 110 Each 2.0000  2 

 Template


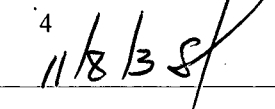

Location Loc Qty Loc Code

ST098 2
 69052 2

CR3212-4-04 Purchased No 110 Each 593.0000  38 

 Cherry Rivet

Location Loc Qty Loc Code

ST311 593
 115698 15
 116471 78
 117816 500

AN3-5A Purchased No 110 Each 768.0000  4 

 Bolt

Location Loc Qty Loc Code

ST350 768
 115371 46
 117423 722

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Shop Packet Print

Page 2

Picklist Print

Wednesday, July 27, 2011 1:57:52 PM

Page 3

Work Order ID: 72512

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 7/27/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-6A
Bolt

Purchased No

110 Each 270.0000 4 4

Location

Loc Qty

Loc Code

ST351

270

117441

270

AN3-7A
Bolt

Purchased No

110 Each 242.0000 4 4

Location

Loc Qty

Loc Code

ST351

242

117313

42

117872

200

AN3-10A
Bolt

Purchased No

110 Each 127.0000 4 4

Location

Loc Qty

Loc Code

ST351

127

117313

11

117795

116

NAS1149D0332J

Purchased No

110 Each 2,693.000 6 6

Washer

Location

Loc Qty

Loc Code

ST297

1586

117087

1586

ST298

1107

105793

12

118078

95

118384

1000

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Shop Packet Print

Page 3

Picklist Print

Page 4

Wednesday, July 27, 2011 1:57:53 PM

Work Order ID: 72512

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning



Start Date: 7/27/2011

Required Date: 7/27/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,351.000

2

2



Nut



11/8/3

10

Location

Loc Qty

Loc Code

ST300

2351

117441

597

117601

400

117885

354

118451

1000

2

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Page 4

Item

Wednesday, July 23

Work Order ID

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
 INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
 INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
 REF FAA STC: SR00563NY
 REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skid tubes in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skid tube.

Procedure:

Note: Installer must be careful not to damage underlying skid tube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skid tube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skid tube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skid tube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skid tube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skid tube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:






The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED

BY: 
 D. SHEPHERD (DE # 02)

DATE: 10.04.14
 CERT. NO.: SH96-88
 ISSUE NO.: 3

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

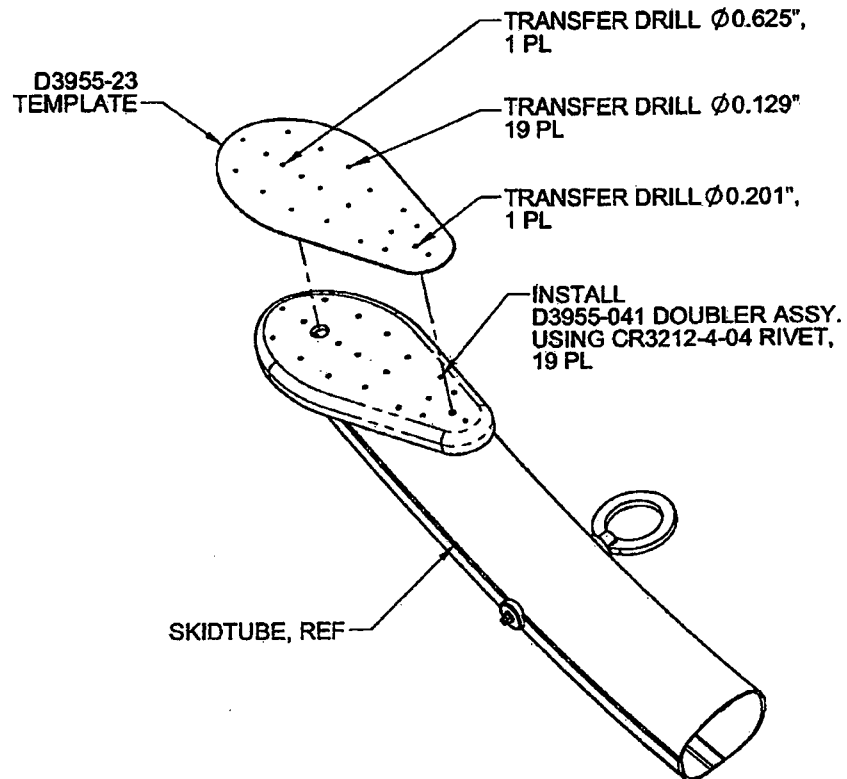


Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

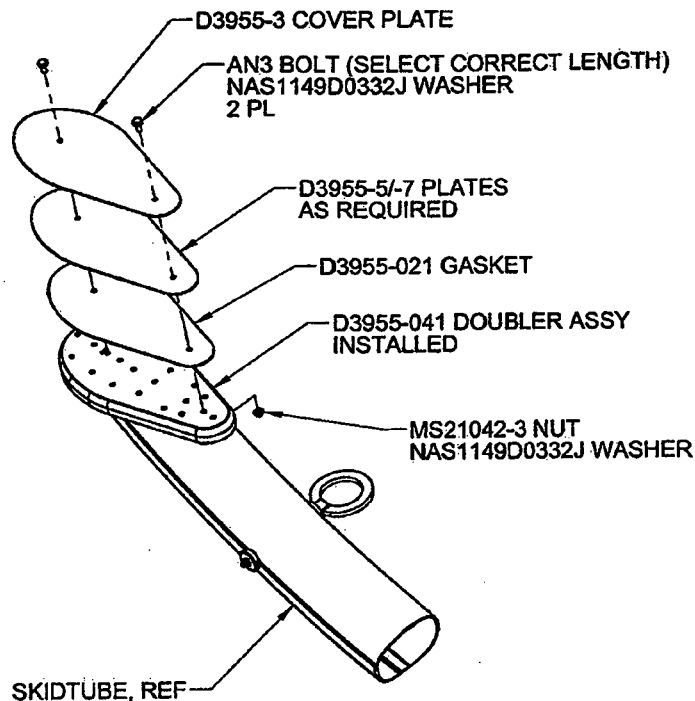


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>gp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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